



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200
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RBW1205G00132-3G

Job Sheet 190216



Part No: RBW1205G00132-3G

Job Qty: 2 pcs

Part Name: Helicopter Servicing



DAG
21
9-89

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No: SIOP

Due Date: 3/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG RBW1205G00132-3G Rev J IPP Rev A 18.02.13 New issue DP Verify DD/IPP Rev. B 19.02.14 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	Small Fab - 1	2 pcs	3/15/19		0.00	0.00	Small Fab - 1		DAS 71 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
100	Small Fab - 2 - B4B	2 pcs	3/15/19		0.00	2.00	Small Fab - 1 - B4B		APR 2 6 2019
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 4	2 pcs	3/15/19		0.00	0.00	QC 4 - 26		DAS 40 9-89
							QC 4 - 28		
							QC 4 - 42		
							QC 4 - 58		
							QC 4 - 6		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
130	Packaging 3-1 - Stock - B4B	2 pcs	3/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		

Plex 3/13/19 3:48 PM dart.leclair.mathieu

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	DAG
				Packaging 3 - 35 - B4B	21
				Packaging 3 - 36 - B4B	8-39
140	QC 21 - FG	2 pcs	3/15/19	0.00 0.00	APR 26 2019
				QC 21 - FG - 21	
				QC 21 - FG - 70	DAG
				QC 21 - FG - 53	21

Part Op **95** - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-Descriptions: 1610-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW1205G00132-3G-9 and RBW1205G00132-3G-11 to RBW1205G00132-3G-19 foam as per DWG. 6-Glue foam to case and pack case as per DWG

100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1610-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW1205G00132-3G-9 and RBW1205G00132-3G-11 to RBW1205G00132-3G-19 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

120 - QC4- 100% Inspect kits for completeness

130 - Identify as per dwg & Stock Location: GA Floor left

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1610-E	Case	2 Ea (1 ea)	95-Small Fab - 1	S163222 / S164100
52375K36	Tubing	10	20 ft (10 ea) 100-Small Fab - 2 - B4B	S1057171
97524A032	Sealing Blind Rivet	4	8 Ea (4 ea) 100-Small Fab - 2 - B4B	S145165
RB41011	Dart Tooling Placard, Aluminum	1	2 Ea (1 ea) 100-Small Fab - 2 - B4B	S1010767
RBW109-3501-08-115	Adapter, Landing Gear Shockstruts Nitrogen Change	2 pcs (1 ea)	100-Small Fab - 2 - B4B	S155405
RBW1205G00132-3G-11	Location Placard	1	2 pcs (1 ea) 100-Small Fab - 2 - B4B	S154413
RBW1205G00132-3G-13	Bottom Foam use in case APP-1610-E	1	2 Ea (1 ea) 100-Small Fab - 2 - B4B	S163225
RBW1205G00132-3G-19	Top Foam use in case APP-1610-E	1	2 Ea (1 ea) 100-Small Fab - 2 - B4B	S163224
RBW1205G00132-3G-9	Contents Placard	1	2 pcs (1 ea) 100-Small Fab - 2 - B4B	S154415
RBW1205G00231-3G	Main Rotor Damper Oil Filling Adapter	1	2 pcs (1 ea) 100-Small Fab - 2 - B4B	S166589
RBW1205G00332-3G	Main Gear Box Oil Draining Hose	1	2 pcs (1 ea) 100-Small Fab - 2 - B4B	S154524
RBW7839-2G	IGB & Tail Rotor Gear Box Oil Draining Hose	1	2 pcs (1 ea) 100-Small Fab - 2 - B4B	S157847
RBWA353A04	Pmc Oil Filling Quick Disconnect	1	2 pcs (1 ea) 100-Small Fab - 2 - B4B	S145132
RBWAFS482B	Wheel Brake Wrench	2	4 pcs (2 ea) 100-Small Fab - 2 - B4B	S154561
RBWSTI3045	Nitrogen Tire Inflator	1	2 pcs (1 ea) 100-Small Fab - 2 - B4B	S162388

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
95-Small Fab - 1	APP-1610-E	21	6	0
100-Small Fab - 2 - B4B	52375K36	2010	70	0
	97524A032	84	221	0
	RB41011	21	380	0
	RBW109-3501-08-115	21	4	0
	RBW1205G00132-3G-11	21	8	0
	RBW1205G00132-3G-13	21	5	0
	RBW1205G00132-3G-19	21	5	0
	RBW1205G00132-3G-9	21	9	0
	RBW1205G00231-3G	21	0	0
	RBW1205G00332-3G	21	4	0
	RBW7839-2G	21	2	0
	RBWA353A04	21	1	0
	RBWAFS482B	42	15	0
	RBWSTI3045	21	0	0

Part Specifications

Specifications could not be found.

Plex 3/13/19 3:48 PM dart.leclair.mathieu



Container No: S175583



Part: RBW1205G00132-3G

Job No: 190216

Serial No/Batch: S175583

Revision: J

Inspector:

Exp Date:

Instructions:

case

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Date: 04/26/19



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RBW1205G00132-3G

Job Sheet 190216



Part No: RBW1205G00132-3G

Job Qty: 2 ea

Part Name: Helicopter Servicing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No: SIOP

Due Date: 3/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG RBW1205G00132-3G Rev 9 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	3/15/19	3/15/19	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	2 pcs	3/15/19	3/15/19	0.00	2.00	Small Fab-5		
120	QC	2 pcs	3/15/19	3/15/19	0.00	0.00	QC4		
130	Packaging	2 pcs	3/15/19	3/15/19	0.00	0.00	Packaging3-1		
140	QC21-FG	2 Ea	3/15/19	3/15/19	0.00	0.00	QC21		

Part Op 100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1610-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW1205G00132-3G-9 and RBW1205G00132-3G-11 to RBW1205G00132-3G-19 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	8 Ea (4 ea)	90-Start up Operation	
52375K36	Tubing	20 ft (10 ea)	100-Small Fab	
APP-1610-E	Case	2 Ea (1 ea)	100-Small Fab	
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	100-Small Fab	
RBW109-3501-08-115	Adapter, Landing Gear Shockstruts Nitrogen Change	2 pcs (1 ea)	100-Small Fab	
RBW1205G00132-3G-11	Location Placard	2 pcs (1 ea)	100-Small Fab	
RBW1205G00132-3G-13	Bottom Foam use in case APP-1610-E	2 Ea (1 ea)	100-Small Fab	
RBW1205G00132-3G-19	Top Foam use in case APP-1610-E	2 Ea (1 ea)	100-Small Fab	
RBW1205G00132-3G-9	Contents Placard	2 pcs (1 ea)	100-Small Fab	
RBW1205G00231-3G	Main Rotor Damper Oil Filling Adapter	2 pcs (1 ea)	100-Small Fab	
RBW1205G00332-3G	Main Gear Box Oil Draining Hose	2 pcs (1 ea)	100-Small Fab	
RBW7839-2G	IGB & Tail Rotor Gear Box Oil Draining Hose	2 pcs (1 ea)	100-Small Fab	
RBWA353A04	Pmc Oil Filling Quick Disconnect	2 pcs (1 ea)	100-Small Fab	
RBWAFS482B	Wheel Brake Wrench	4 pcs (2 ea)	100-Small Fab	
RBWST13045	Nitrogen Tire Inflator	2 pcs (1 ea)	100-Small Fab	

Job Allocations

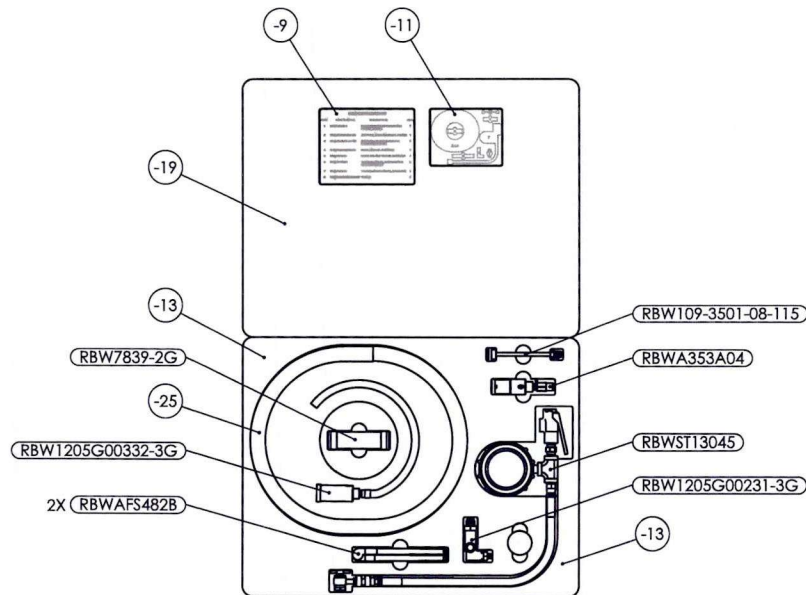
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation 100-Small Fab	97524A032	8	526	0
	52375K36	20	45	0
	APP-1610-E	2	5	0
	RB41011	2	425	0
	RBW109-3501-08-115	2	1	0
	RBW1205G00132-3G-11	2	0	0
	RBW1205G00132-3G-13	2	4	0
	RBW1205G00132-3G-19	2	4	0
	RBW1205G00132-3G-9	2	0	0
	RBW1205G00231-3G	2	0	0
	RBW1205G00332-3G	2	1	0
	RBW7839-2G	2	2	0
	RBWA353A04	2	0	0
	RBWAFS482B	4	3	0
	RBWST13045	2	0	0

Part Specifications

Specifications could not be found.

Plex 2/6/19 8:35 AM Dart.Macdonald.Dara

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED -19 TOOL TOP CUSHION AND PAGE 4.	4/31/2010	WP	RW
2		ADDED RADI TO L SHAPE CUT OUT FOR BETTER FINGER ACQUISITION.	5/6/2010	WP	RW
3		DELETED -1A, -1B, -1C FROM BOTTOM CUSHION & ATTACHED TO HOSE. DELETED Ø6.00 CUTOFF FROM CENTER OF BOTTOM CUSHION. CHD DEPTH OF HOSE CUT OUT FROM 4.75 TO 3.75. CHD CENTER POST FROM Ø8.25 TO Ø3.50 TO ALLOW MORE ROOM FOR HOSES. CHD BOM T/N -1, -3, & -5. CHD -15 FROM IM2700 CASE. CORRECTED -3 P/N FROM RBW109-3501-08-115.	4/21/2011	RJC	DW
4		SHT 3 UPDATED -7 CUTOFF. SHT. 4 ADDED CUTOFFS FOR TIRE INFLATOR. REMOVED FROM BOX.	12/27/2011	JAG	
5		-11 MODIFIED PLACARD TO MATCH BOTTOM TOOL CUSHION -13 MODIFIED CUTOFF FOR TIRE INFLATOR. ADDED CUTOFF FOR -1, MOVED CUTOFFS FOR FIT.	4/25/2012	JAG	
6		CORRECTED -19 Ø1.20 HOLE CUT OUT LOCATION 180° TO FIT LID PROPERLY.	9/24/2012	RJC	SE
7		-11 MODIFIED PLACARD FOR RBW7839-2G. -13 (FOAM) MODIFIED CUTOFF Ø TO ALLOW FOR RBW7839-2G. -19 CHD PLACARD CUTOFF DEPTH WAS .07 IS .125	1/17/2013	BIM	SE
8		REDRAWN IN SOLIDWORKS. -9 CORRECTED ITEM -3 T/N WAS RBW109-351-08-115 IS RBW109-3501-08-115. ADDED -21 & -23 RIVET AND WASHER FOR PLACARD. -9 & -11 WAS B/O IS MANUFACTURED. -19 CHD LOCATION OF CUTOFF ON BACKSIDE.	10/14/2013	JAG	RW
9	17-0122	CHD DRAWING NUMBER WAS RBW1205G00131-3G IS RBW1205G00132-3G. UPDATED TO NEW STANDARD. -1 REPLACED W/ RBWA353A04. -2 REPLACED W/ RBW1205G00231-3G. -3 REPLACED W/ RBW109-3501-08-115. -4 REPLACED W/ RBW1205G00332-3G. -5 REPLACED W/ RBW7839-2G. -6 REPLACED W/ RBWAFS482B. -7 REPLACED W/ RBWST13045. -9 DELETED DIMS ARIAL SIZE 1/8. ARIAL SIZE 3/16. CHD DIM WAS (.06) IS .06. CHD TOLERANCES WAS ±.005 IS ±.010. WAS ±.01 IS ±.03. ADDED ITEM 8 TUBING TO PLACARD. -11 ADDED ITEM #8. CHD DIM WAS (.06) IS .06. CHD TOLERANCES WAS ±.005 IS ±.010. WAS ±.01 IS ±.03. -13 REDESIGNED TO FIT -25. CHD DIMS WAS .50 IS .50. WAS .43 IS .50. CHD B/O REF WAS 5.83 X 14.42 X 18.87 L/R. SPECIALTY IS 8.40 X 17.21 X 20.30 (CASE SOLUTIONS). CHD MATL WAS 120 BLACK IS ETHAFOAM 220 BLACK. CHD TOLERANCES WAS ±.005 IS ±.010. WAS ±.01 IS ±.03. CHD DIM WAS 4X 8.50 IS 10X 8.50. DELETED DIM 2X 8.50 X .50. ADDED DIM # 1.00. -18 CHD B/O REF WAS RAPP-1550-E IS RAPP-1610-E. -17 REPLACED W/ RBW1011. -19 CHD B/O REF WAS 1.75 X 14.22 X 18.63 L/R. SPECIALTY IS 2.01 X 17.21 X 22.30 (CASE SOLUTIONS). CHD MATL WAS 120 BLACK IS ETHAFOAM 220 BLACK. REDESIGNED TO FIT IN LARGER CASE. CHD TOLERANCES WAS ±.005 IS ±.010. WAS ±.01 IS ±.03. -26 TUBING ADDED TO BOM QTY 1.	6/19/2017	DPD	JAG

ASSY QTY	B/O	Part #	QTY.	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			1	PMC OIL FILLING QUICK DISCONNECT		RBWA353A04	1
			1	ADAPTER, M/R DAMPER OIL FILLING		RBW1205G00231-3G	1
			1	ADAPTER, L/G SHOCKSTRUTS NITROGEN CHARGE		RBW109-3501-08-115	1
			1	HOSE, MGB OIL DRAINING		RBW1205G00332-3G	1
			1	HOSE, IGB & TGB OIL DRAINING		RBW7839-2G	1
			2	WRENCH, WHEEL BRAKE RESER COVER REM/INST		RBWAFS482B	1
			1	TIRE INFLATOR GAUGE, NITROGEN		RBWST13045	1
		-9	1	CONTENTS PLACARD	PLASTIC		2
		-11	1	LOCATION PLACARD	PLASTIC		3
	B/O	-13	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	8.40 X 17.21 X 20.30 (CASE SOLUTIONS)	4
	B/O	-15	1	CASE	PLASTIC	PELICAN #APP-1610-E	N/S
	B/O	-19	1	TOP FOAM	ETHAFOAM 220, BLACK	2.01 X 17.21 X 22.30 (CASE SOLUTIONS)	5
	B/O	-25	1	TUBING	PVC W/ POLYESTER BRAID	Ø3/4 I.D., X Ø1-1/32 O.D., X 10FT, DUROMETER 70A (MCMMASTER-CARR #52375K34)	1
	B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S

NOTE:
REF. AGUSTA T/N: 3G1205G00132.

DART AEROSPACE																							
TITLE HELICOPTER SERVICING KIT																							
DWG NO. RBW1205G00132-3G	REV 9																						
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>TREAT</td> <td>.00X ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>FINISH</td> <td>.00X ± .01 ANGLES ± .5°</td> </tr> <tr> <td></td> <td>.00X ± .1 SURFACES ± .125</td> </tr> <tr> <td>SPEC</td> <td>1. BREAK ALL SHARP EDGES</td> </tr> <tr> <td></td> <td>.015 X .45° OR .015R</td> </tr> <tr> <td></td> <td>2. DIMENSIONAL LIMITS APPLY</td> </tr> <tr> <td></td> <td>AFTER PLATING</td> </tr> <tr> <td></td> <td>3. INTERPRET DIM AND TOL PER</td> </tr> <tr> <td></td> <td>ASME Y14.5M-2009</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT	DIMENSIONS ARE IN INCHES	TREAT	.00X ± .005 FRACTIONS ± 1/8	FINISH	.00X ± .01 ANGLES ± .5°		.00X ± .1 SURFACES ± .125	SPEC	1. BREAK ALL SHARP EDGES		.015 X .45° OR .015R		2. DIMENSIONAL LIMITS APPLY		AFTER PLATING		3. INTERPRET DIM AND TOL PER		ASME Y14.5M-2009
MAT'L	UNLESS OTHERWISE SPECIFIED																						
HEAT	DIMENSIONS ARE IN INCHES																						
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	AFTER PLATING																						
	3. INTERPRET DIM AND TOL PER																						
	ASME Y14.5M-2009																						
DRAWN BY: PERRITT																							
CHECKED BY: RJC 07/10/2017																							
OPPS APPR: AA 07/14/2017																							
QA APPR: JL 07/19/2017																							
APPROVED: JAG 07/20/2017																							
SCALE 1:8	DATE 4/20/2010 SHEET 1 OF 5																						

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8		-9 CORRECTED ITEM -3 T/N WAS RBW109-351-08-115 IS RBW109-3501-08-115.	10/15/2013	CFS	RW
9	17-0122	-9 DELETED DIMS ARIAL SIZE 1/8, ARIAL SIZE 3/16, CH'D DIM WAS (.06) IS .06. CH'D TOLERANCES WAS $\pm .005$ IS $\pm .010$, WAS $\pm .01$ IS $\pm .03$. ADDED ITEM 8 TUBING TO PLACARD.	6/19/2017	DPD	JAG

4X R.13

BLACK BACKGROUND W/
WHITE LINES & LETTERS

RBW1205G00132-3G				
ITEM	PART NUMBER	DESCRIPTION	QTY.	
1	RBWA353A04	QUICK DISCONNECT COUPLING PCM OIL FILLING	1	
2	RBW1205G00231-3G	ADAPTER, M/R DAMPER OIL FILLING	1	
3	RBW109-3501-08-115	ADAPTER, L/G SHOCKSTRUTS NITROGEN CHARGE	1	
4	RBW1205G00332-3G	HOSE, MGB OIL DRAINING	1	
5	RBW7839-2G	HOSE, IGB AND TGB OIL DRAINING	1	
6	RBWAFS482B	WRENCH, WHEEL BRAKE RESER COVER REMINST	2	
7	RBWST13045	TIRE INFLATOR GAUGE, NITROGEN	1	
8	RBW1205G00132-3G-25	TUBING	1	

5.00

6.25

.06

RBW1205G00132-3G			
ITEM	PART NUMBER	DESCRIPTION	QTY.
1	RBWA353A04	QUICK DISCONNECT COUPLING PCM OIL FILLING	1
2	RBW1205G00231-3G	ADAPTER, M/R DAMPER OIL FILLING	1
3	RBW109-3501-08-115	ADAPTER, L/G SHOCKSTRUTS NITROGEN CHARGE	1
4	RBW1205G00332-3G	HOSE, MGB OIL DRAINING	1
5	RBW7839-2G	HOSE, IGB AND TGB OIL DRAINING	1
6	RBWAFS482B	WRENCH, WHEEL BRAKE RESER COVER REMINST	2
7	RBWST13045	TIRE INFLATOR GAUGE, NITROGEN	1
8	RBW1205G00132-3G-25	TUBING	1

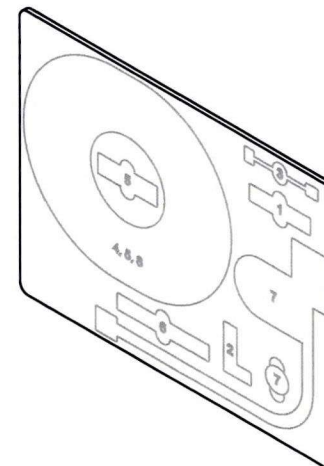
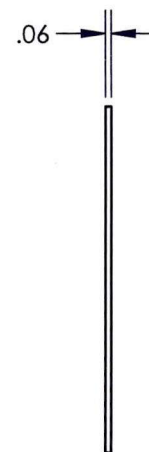
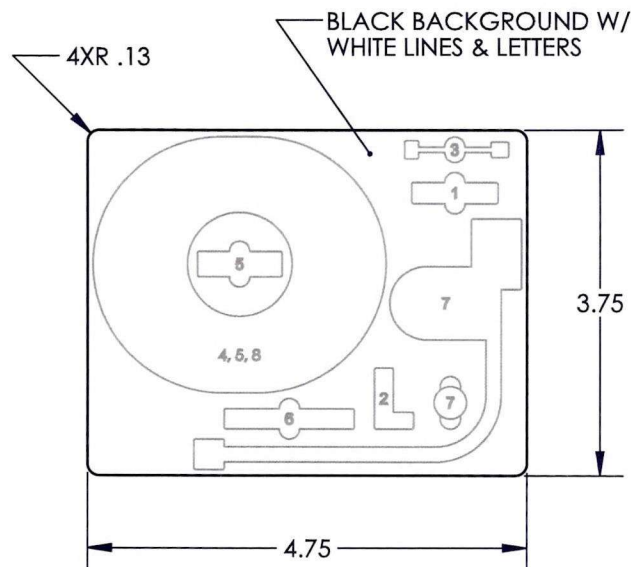
(-9)

CONTENTS PLACARD

DART AEROSPACE	
TITLE HELICOPTER SERVICING KIT	
DWG NO. RBW1205G00132-3G-9	REV 9
MAT'L PLASTIC HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.010 FRACTIONS $\pm$ 1/8 .XX $\pm$.03 ANGLES $\pm$ 1° .X $\pm$.1 SURFACES = 125/✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: SMITH	USED ON MODEL
CHECKED: RJC 07/10/2017	AGUSTA AW139
OPPS APPR: AA 07/14/2017	
QA APPR: JL 07/19/2017	
APPROVED: JAG 07/20/2017	
SCALE 1:2	DATE 10/14/2013 SHEET 2 OF 5

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
9	17-0122	-11 ADDED ITEM #8. CH'D DIM WAS (.06) IS .06. CH'D TOLERANCES WAS ±.005 IS ±.010, WAS ±.01 IS ±.03.	6/19/2017	DPD	JAG

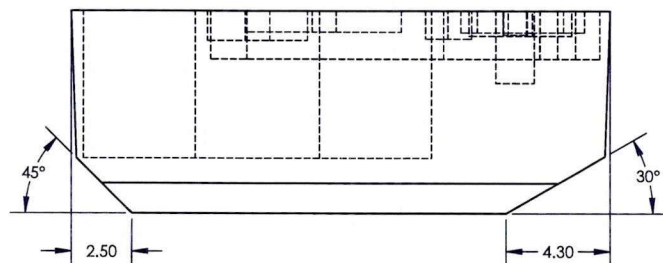
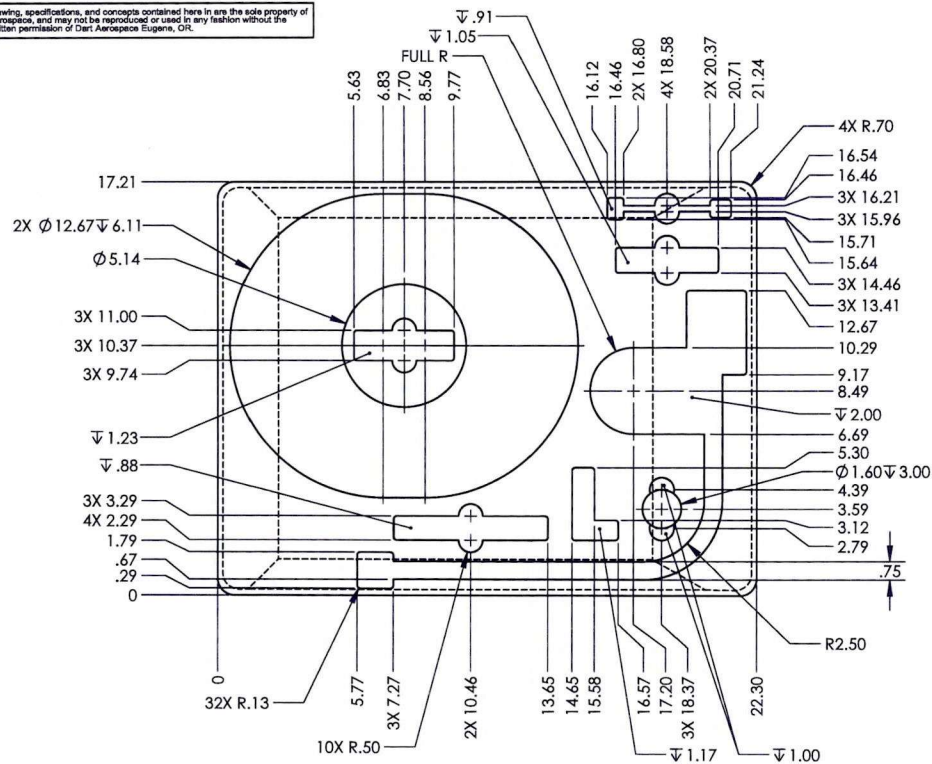


(-11)

LOCATION PLACARD

DART AEROSPACE	
TITLE HELICOPTER SERVICING KIT	
DWG NO. RBW1205G00132-3G-11	REV 9
MAT'L PLASTIC	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX $\pm$.010 FRACTIONS $\pm$ 1/8
SPEC	XX $\pm$.03 ANGLES $\pm$ 1°
	X $\pm$.1 SURFACES = 125/✓
DRAWN BY: SMITH	1. BREAK ALL SHARP EDGES
CHECKED: RJC 07/10/2017	.015 x 45° OR .015R
OPPS APPR: AA 07/14/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 07/19/2017	AFTER PLATING
APPROVED: JAG 07/20/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	USED ON MODEL
DATE 10/14/2013	AGUSTA AW139
SHEET 3 OF 5	

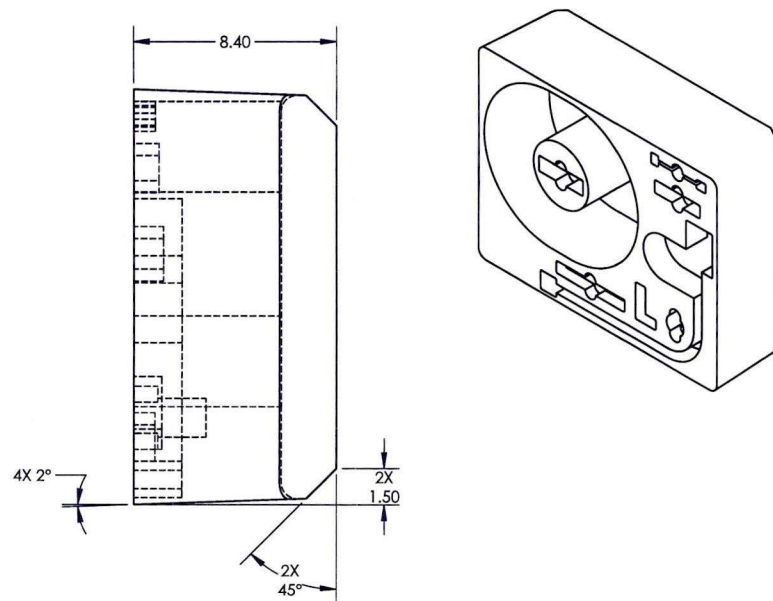
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(-13)

BOTTOM FOAM

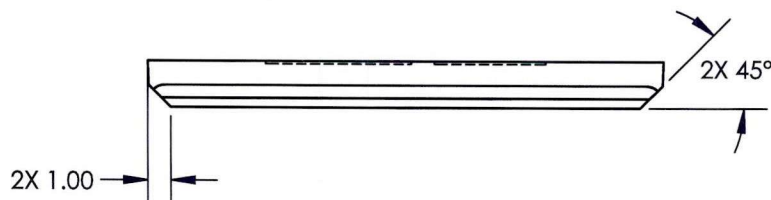
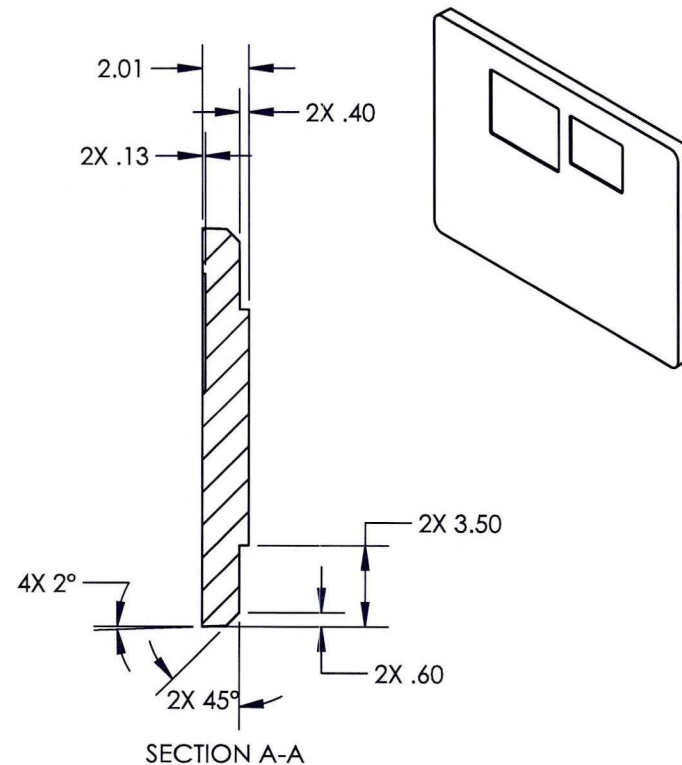
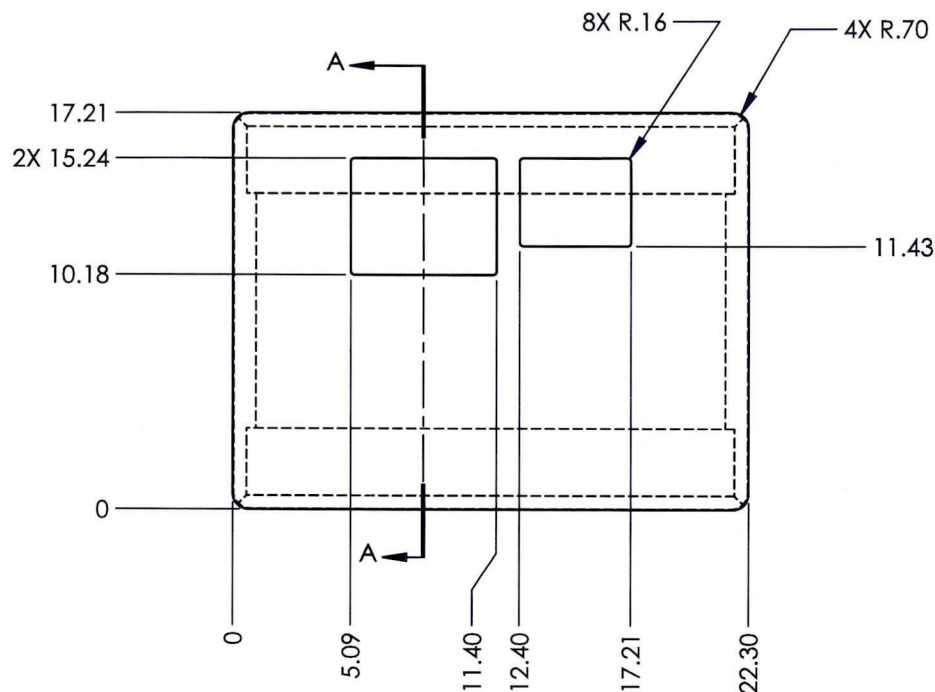
REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
9	17-0125	-13 REDESIGNED TO FIT -25, CHD DIMS WAS ±.30 IS ±1.00, WAS ±.63 IS ±.91, CHD R/O REF WAS 3.83 X 14.42 X 18.87 I.R. SPECIALTY IS 8.40 X 17.21 X 20.30 (CASE SOLUTIONS), CHD MATL WAS 120 BLACK IS ETHAFOAM 220 BLACK, CHD TOLERANCES WAS ±.005 IS ±.010, WAS ±.01 IS ±.03, CHD DIM WAS 4X R.50 IS 10X R.50. DELETED DIM 2X R.50 ±.50, ADDED DIM ±1.00.	6/19/2017	DPD
				JAG



DART AEROSPACE			
TITLE HELICOPTER SERVICING KIT			
DWG NO.	RBW1205G00132-3G-13		REV 9
MAT'L	ETHAFOAM 220, BLACK		
REAT	UNLESS OTHERWISE SPECIFIED		
TREAT	DIMENSIONS ARE IN INCHES		
FINISH	.XXX ± .010 FRACTIONS ± 1/8		
SPEC	.XX ± .03 ANGLES ± 1°		
	X ± .1 SURFACES ± 125		
DRAWN BY:	PERRITT		
CHECKED:	RJC 07/10/2017		
OPPS APPR:	AA 07/14/2017		
QA APPR:	JL 07/19/2017		
APPROVED:	JAG 07/20/2017		
SCALE	1:5	DATE	4/20/2010
		SHEET	4 OF 5

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
9	17-0122	-19 REDESIGNED TO FIT IN LARGER CASE. CH'D TOLERANCES WAS $\pm .005$ IS $\pm .010$, WAS $\pm .01$ IS $\pm .03$. CH'D B/O REF WAS 1.73 X 14.22 X 18.43 I.R. SPECIALTY IS 2.01 X 17.21 X 22.30 (CASE SOLUTIONS). CH'D MAT'L WAS Y20 BLACK IS ETHAFOAM 220 BLACK.	6/19/2017	DPD
				JAG



(-19)
TOP FOAM

DART AEROSPACE	
TITLE HELICOPTER SERVICING KIT	
DWG NO. RBW1205G00132-3G-19	REV 9
MAT'L ETHAFOAM 220, BLACK	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	XXX $\pm .010$ FRACTIONS $\pm 1/8$
FINISH FINISH	XX $\pm .03$ ANGLES $\pm 1^\circ$
SPEC SPEC	X $\pm .1$ SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 07/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/14/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/19/2017	USED ON MODEL
APPROVED: JAG 07/20/2017	AGUSTA AW139
SCALE 1:8	DATE 4/20/2010
SHEET 5 OF 5	